

Date: Monday, 2/5/2007 8:07:00 AM
User: Kim Johnston

Process Sheet

SPLIT - 1

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
 Job Number : 30593 -2
 Estimate Number : 10531
 P.O. Number : N/A
 This Issue : 2/5/2007 S.O. No : N/A
 Part Number : D2572
 Drawing Number : D2572 REV E
 Project Number : N/A
 First Issue : NC
 Drawing Revision : E
 Previous Run : 30213
 Material : N/A
 Due Date : 2/15/2007 Qty: 12 U/m: Each
 Written By :
 Checked & Approved By : J. 07.02.05
 Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Additional Product

Number



Seq. #: Machine Or Operation: Description:
 0 D6101005 7075-T7351 8.25X5.0X2.5



Comment Qty: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2572
 Ensure that grain is along 5.00" length
 Batch No: 25352

1 HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 030573 Double check by: JF

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

30 MILLING CONV

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

40 002

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 30593

Part Number: D2572

Job Number



Seq. #:

Machine Or Operation:

Description:

5.0

QCR

SECOND CHECK



Comment: SECOND CHECK

J.L 07/04/16

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FSL

07/04/16 (9)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

FSL

07/04/16 (9)

8.0

QCR

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

U 07-04-16

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

U 07-04-16

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/16 (3)

at Completion



U 07-04-16

DART AEROSPACE LTD		Work Order: 30593
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.746	1.749	1.748		
C	3.495	3.505		3.500	3.499	3.500	3.500		
D	1.745	1.755		1.750	1.746	1.749	1.748		
E	7.990	8.010		8.002	8.004	8.002	8.001		
F	0.490	0.510		0.503	0.498	0.494	0.492		
G	0.257	0.262	DT8683	0.260	0.259	0.259	0.257		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.502	0.498	0.495	0.500		
J	1.174	1.184		1.179	1.177	1.179	1.178		
K	0.558	0.578		0.561	0.562	0.566	0.564		
L	1.174	1.184		1.179	1.177	1.179	1.178		
M	1.490	1.500		1.495	1.491	1.491	1.493		
N	2.495	2.505		2.500	2.500	2.500	2.498		
O	3.869	3.879		3.871	3.872	3.872	3.873		
P	0.115	0.135		0.132	0.132	0.131	0.134		
Q	0.115	0.135		0.135	0.131	0.131	0.131		
R	0.240	0.260		0.255	0.254	0.256	0.256		
S	0.115	0.135		0.132	0.124	0.130	0.131		
T	0.178	0.198		0.187	0.189	0.189	0.180		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.245	0.241	0.233	0.236		
W	0.115	0.135		0.130	0.131	0.130	0.131		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.762	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.367	0.365	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.625	0.628	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.251	0.245	0.248		
AE	1.375	1.395		1.387	1.386	1.388	1.388		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.250	0.260	0.260	0.260		
AH	0.240	0.260		0.253	0.270	0.247	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by: <i>En</i>	Audited by: <i>AS</i>
Date: <i>07/04/13</i>	Date: <i>01-05-13</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format: Added Rev. D	KJ	
C	02.10.11	Re-format: Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	

DART AEROSPACE LTD		Work Order:	30593
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.001	8.001		
F	0.490	0.510		0.500	0.500	0.500	0.500		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.495	0.496	0.492	0.496		
J	1.174	1.184		1.177	1.178	1.178	1.178		
K	0.558	0.578		0.567	0.567	0.563	0.567		
L	1.174	1.184		1.177	1.178	1.178	1.178		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.871	3.871	3.871		
P	0.115	0.135		0.134	0.131	0.131	0.131		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.255	0.254	0.254	0.254		
S	0.115	0.135		0.135	0.135	0.135	0.135		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.231	0.244	0.238	0.241		
W	0.115	0.135		0.125	0.135	0.135	0.135		
X	0.307	0.312		0.311	0.307	0.309	0.309		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.626	0.625	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.250	0.248	0.248		
AE	1.375	1.395		1.370	1.384	1.383	1.383		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.255	0.244	0.255		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	CP
Date:	07/01/13

Audited by:	JL
Date:	07/01/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 30593
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below.

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440					
B	1.745	1.755		1.750					
C	3.495	3.505		3.500					
D	1.745	1.755		1.748					
F	7.990	8.010		8.000					
F	0.490	0.510		0.501					
G	0.257	0.262	DT8683	0.259					
H	0.375	0.380	DT8684	0.376					
I	0.490	0.510		0.500					
J	1.174	1.184		1.178					
K	0.558	0.578		0.568					
L	1.174	1.184		1.178					
M	1.490	1.500		1.495					
N	2.495	2.505		2.500					
O	3.869	3.879		3.871					
P	0.115	0.135		0.127					
Q	0.116	0.135		0.125					
R	0.240	0.260		0.252					
S	0.115	0.135		0.124					
T	0.178	0.198		0.188					
U	2.940	2.980		2.960					
V	0.230	0.250		0.238					
W	0.115	0.135		0.129					
X	0.307	0.312		0.310					
Y	0.760	0.765		0.765					
Z	0.352	0.372		0.360					
AA	0.470	0.530		0.500					
AB	0.615	0.635		0.627					
AC	0.053	0.073		0.063					
AD	0.240	0.260		0.249					
AE	1.375	1.395		1.378					
AF	0.115	0.135		0.128					
AG	0.240	0.280		0.266					
AH	0.240	0.260		0.251					
AI	2.000	2.020		2.000					
AJ	0.023	0.043		0.033					
Accept/Reject									

Measured by:	JLM
Date:	07/04/14

Audited by:	JL
Date:	07/04/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

